

D206-628-033

Dart Aerospace Ltd.

Date: Wednesday, 13/05/2009 11:28:21 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: FLOAT STEP ASSEMBLY LH (206/407)
<b>Job Number</b>	: 47932A		
<b>Estimate Number</b>	: 11664		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D2842041
<b>This Issue</b>	: 13/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b>	: D2842 REV B
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b>	: B
<b>Previous Run</b>	: 46696A	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 20/05/2009 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b>	: <u>JLD 09.05.13</u>		
<b>Comment</b>	: Est Rev:D As Per Ecn 766 06-01-06 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D2622120C	Step Extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit    Total : 6.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<u>345494</u>

Check Material for any Dents or Defects

PK 09.05.14

6

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

2-Drill D2842-1 using Jig DT8271 as per Dwg D2842

3-Deburr and bevel ends for welding

PK 09.05.14

6

PK 09.05.14

6

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEPPK 09.05.14 (46)

4.0	D2734	Step End Plate
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**Comment:** Qty.: 2.0000 Each(s)/Unit    Total : 12.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<u>343535</u>

PK 09.05.14

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 13/05/2009 11:28:22 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 47932A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34593

Float Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3459-3 Lug

346864

PL 09.05.20 6

6.0

D34591

Float Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3459-1 Lug

346864

PL 09.05.20 6

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs using Jig DT

followed by DT

as per Dwg D2842

A/R AL Rod Batch: M11C130

M11C972

2-Grind end cap weld flush

PL 09.05.20 6

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SD 09.05.27 (6)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/05/27 (X64H)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UMD 09/05/27

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Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 47932A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 09-05-27

6

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding. SAD 09-05-27 6

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: M110130

2-Grind end cap weld flush.

09-05-27 6  
09-05-28 6

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-05-28 6

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09-05-28 6 LH

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING + pressure wash 09-05-28 6 LH

✓ Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 3:20 PM

OVEN TEMPERATURE: 320°F

FINISH TIME: 3:50 PM

09-05-28 6 LH

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-05-29 6 LH

17.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Insert

Pick:

Qty Part Number

Description Batch

3 NAS1329C3KB130 Insert M106957

09-05-29

Date: Wednesday, 13/05/2009 11:28:22 AM  
User: Julie Dawson

## Process Sheet

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Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 47932A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

MS27039C1-07

Screw

M 110002(11) M 111424

BR

19.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description Batch

3

NAS1515H3L

WASHER

M 110806

BR.

20.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

AN960C10L

WASHER

M 111808

BR.

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: LARGE FABRICATION RESOURCE 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch:

M 111013

BR 09-05-29

⑥

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S09106/01 464H

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPR 47932

PC 9/6/01 ⑥

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Job Number: 47932A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/01  
MF

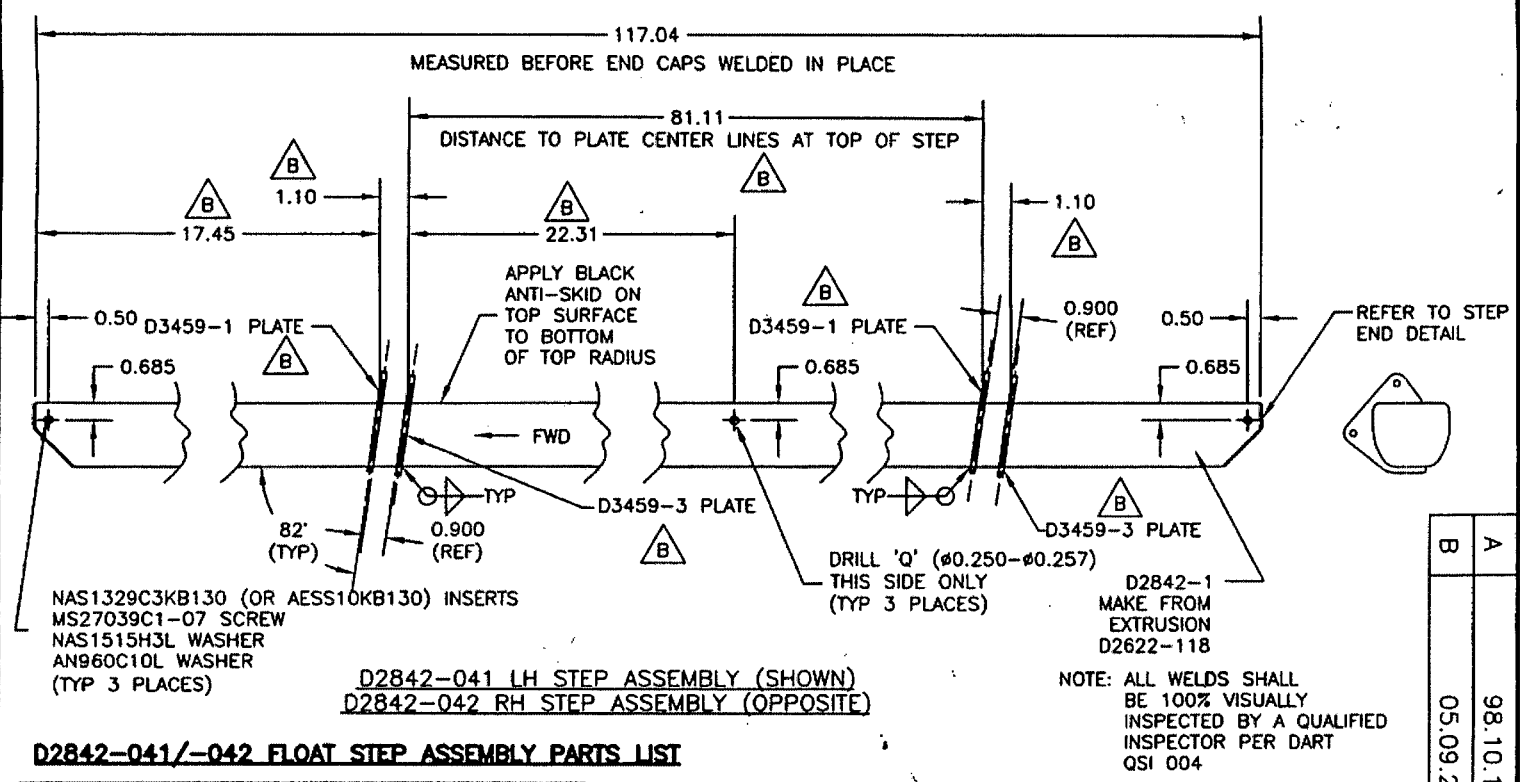
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-06-01

**DART**

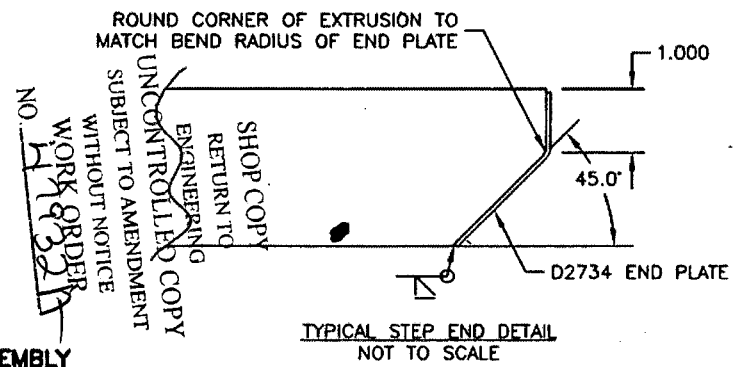


NAS1329C3KB130 (OR AESS10KB130) INSERTS  
 MS27039C1-07 SCREW  
 NAS1515H3L WASHER  
 AN960C10L WASHER  
 (TYP 3 PLACES)

D2842-041 LH STEP ASSEMBLY (SHOWN)  
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

**D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2842-041	LH STEP ASSEMBLY
		D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



**D2842-041/-042 FLOAT STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
 APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	KE	DRAWN BY	PH	<b>DART AEROSPACE USA, INC.</b>
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.23	TITLE	D2842	REV. B
			206L/407 FLOAT STEP ASSEMBLY	SHEET 1 OF 1
	A	98.10.13	NEW ISSUE	SCALE
	B	05.09.23	RE-DESIGN, ADD D3459-1/-3	NTS

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 05.11.14